

Date: Wednesday, 10/12/2008 7:51:56 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : T-BEAM EXTRUSION
Job Number : 43959	
Estimate Number : 10043	
P.O. Number :	Part Number : D6201
This Issue : 10/12/2008 S.O. No. :	Drawing Number : D6201 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 36793	Material :
Written By :	Due Date : 17/12/2008 Qty: 20 Um: F
Checked & Approved By : <u>C208112110</u>	
Comment : Est. A: 01.05.15 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7805C20811211020 ft

a) Description: T-beam extrusion

b) 4.00" x 4.00" x 0.375"

c) Minimum Ultimate Tensile Strength = 38ksi

d) Minimum Yield Tensile strength = 35ksi

e) Material: 6061-T6/T6511 (QQ-A-200/8)

f) Material certification required

2.0	D6201P	T Extrusion 4X4X3/8
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Comment: Qty.: 1.0000 f(s)/Unit Total : 20.0000 f(s)
 T Extrusion 4X4X3/8

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6104

8/12/15 20
0812-16 20 970

W/O: 43959		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D6201 PAR #: N/A Fault Category: Supplier / Mfg ^{Shrink} NCR: Yes No DQA: D Date: 08/12/16
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/12/16

NCR: 43959		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/16	3.0	Material dims are slightly undersize and at minimum tolerance. Also some minor damage at 30.250" -> 33.250" on 1 side of the material from transport & handling. R.C. Supplier P/O 7805	CP 08.12.16 pw QSI042	Dims are acceptable. Cut-off / scrap damaged section of mat'l. Notify supplier of the issue.	ml 08/12/16 QSI042 08/12/16	08/12/16 08/12/16	CP 08.12.16 pw QSI042	08/12/16

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: T-BEAM EXTRUSION

Job Number: 43959

Part Number: D6201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

mf 08/12/16

(20)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16

Job Completion



608-1206

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

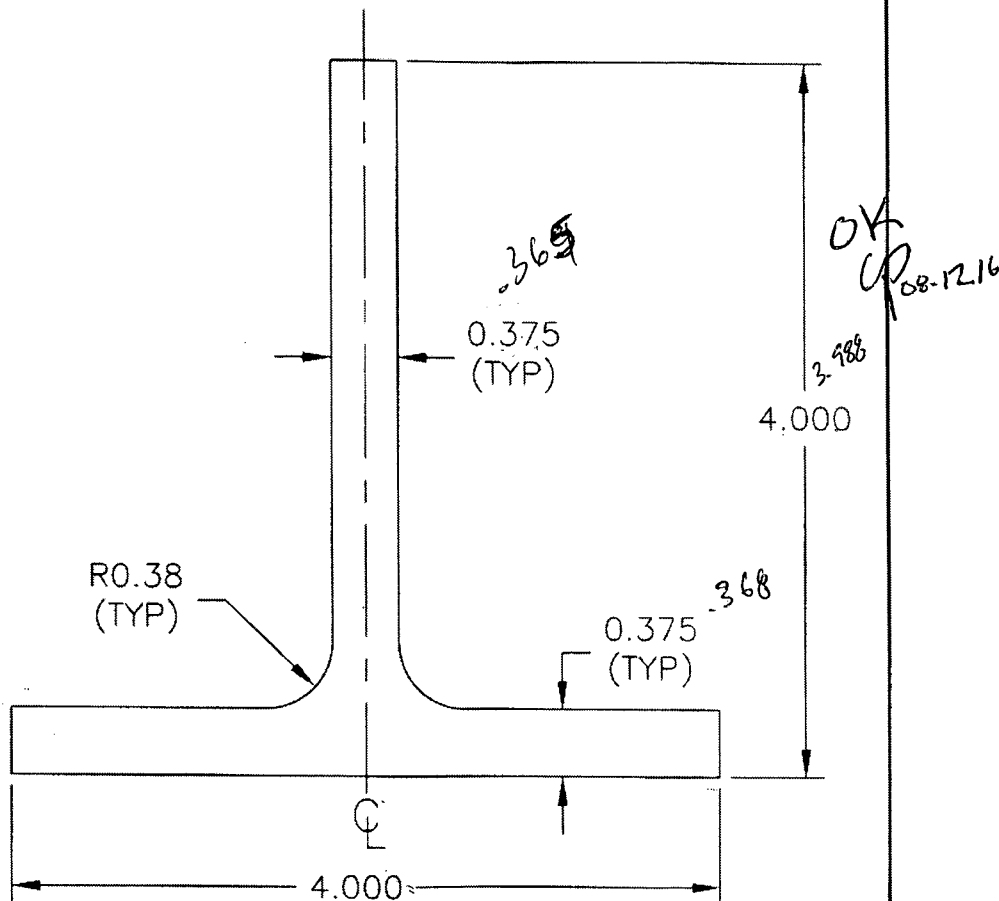


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>CP</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. B 43959



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.

D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I004575

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

STOCK
MUST HAVE HT

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	7805	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W005179	NET 30 DAYS		TARGET	12/11/08	12/12/08	12/12/08

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
4		PC	ALUMINUM ROUND BAR ARB 6061 T6 5/8" x R/L 20' 30 LB / 4 PC	L015572	4509	4
1	✓	PC	ALUMINIUM TEE ATE 6061 T6 3/8" x 4" x 4" x R/L 20' 69 LB / 1 PC	L007892	70306401	1
Bundles: 1				Total Weight:		99 LB

Received by:  Date: _____ Signature: _____

PANASIA ALUMINIUM (CHINA) LIMITED

Aluminium Mill Certificate

Cert. No.: PAAV-MC0703036

CUSTOMER: Magna Stainless Inc

PO No.: 065464-JC

Contract No.: NIL

Alloy & Temper: 6061-T6511

Standards: ASTM-B308

QQA-2008

Container No.: ZCSU9010606

Date of shipment: 2007.03.12

SAE AMS QQA-2008

ASTM B308 acceptable.

equivalent to

08.12.16

Chemical Composition (%)

Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Al
Standard	0.40-0.80	0.80-1.20	0.7max	0.15-0.40	0.15max	0.25max	0.04-0.35	0.15max	Rem.
20070306401	0.489	0.880	0.242	0.194	0.028	0.038	0.047	0.018	Rem.

Tensile Test Result

Heat No.	Die No.	Customer part No.	Description	Tensile Strength		Yield Strength		Elongation
				N/mm ²	Ksi	N/mm ²	Ksi	
20070306401	C10000071		Channel 6x2.5x0.25	280	41	255	37	11.0
20070306401	E10000004		Tee 4x4x0.375	285	42	255	37	10.8
20070306401	C10051		Channel 4x2x0.187	290	42	265	39	10.9

Hardness Test Result

Section No.	HRE	Webster	Other Remarks
C10000071	91	15.8	
E10000004	94	16.2	
C10051	92	15.9	

The above result was done on testing samples and the mill shall guarantee the same quality for the same batch of products. It is certified that this material conforms in all respects to the requirements of the above standards latest revision.

QC: Chenghao Zhong

Checked By: Junxian Luo



BW-550

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